

Work Order ID 74742

Wednesday, October 05, 2011 2:37:54 PM



Page 1

Item ID:	D3783-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lateral Brace Assembly					
Start Date:	10/5/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	10/14/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-10-5	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3783	Rev A

100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
11/10/27 (2)									
110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-assemble as per dwg D3783								
11/10/27 (2)									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
11/10/27 (2)									

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	***Mask inside D3765-1 clevis***								
	POWDER COAT: 1:50								
	Start Time: 320 OF								
	Oven Temperature: 320								
	Finish Time: 2:25								
127 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
130 	Identify as per dwg & Stock Location: 5249 A	0.00							
Packaging	Memo	0.00							
Packaging									

2x DM-11/4/01

2 BR 11-10-1

2x SP 11-11-02.

M 118489

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Item ID: D3783-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lateral Brace Assembly

Start Date: 10/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/02 [Signature]

11-11-02
②

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Wednesday, October 05, 2011 2:38:01 PM

Parent Item: D3783-041

Parent Item Name: Lateral Brace Assembly





Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.a as per dwg DD verified by:EC IPP RevC: add
powder coat for ease of manufacturing DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-13A 		Purchased	No			110	Each	86.0000	2	4			
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MEZZ				36					
					116003			36		4			
				ST338				50					
					118983			50					
AN960JD516 	NAS1149D0563J	Purchased	No			110	Each	0.0000	4	8			
Washer													
D3765-1 		Manufactured	No			110	Each	7.0000	2	4			
Clevis													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST243				7					
					64766			7		4			
D3769-1 		Manufactured	No			110	Each	4.0000	1	2			
Tube													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST251A				4					
					60454			4		2			

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 2:38:01 PM

Page 2

Work Order ID: 74742

Parent Item: D3783-041

Parent Item Name: Lateral Brace Assembly



Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

110

Each

2,680.000

2

4



Nut



EP 11/10/27

Location

Loc Qty

Loc Code

ST300

1180

116105

5

116548

53

117441

244

117611

82

118179

496

118910

300

ST518

1500

119109

1500

4

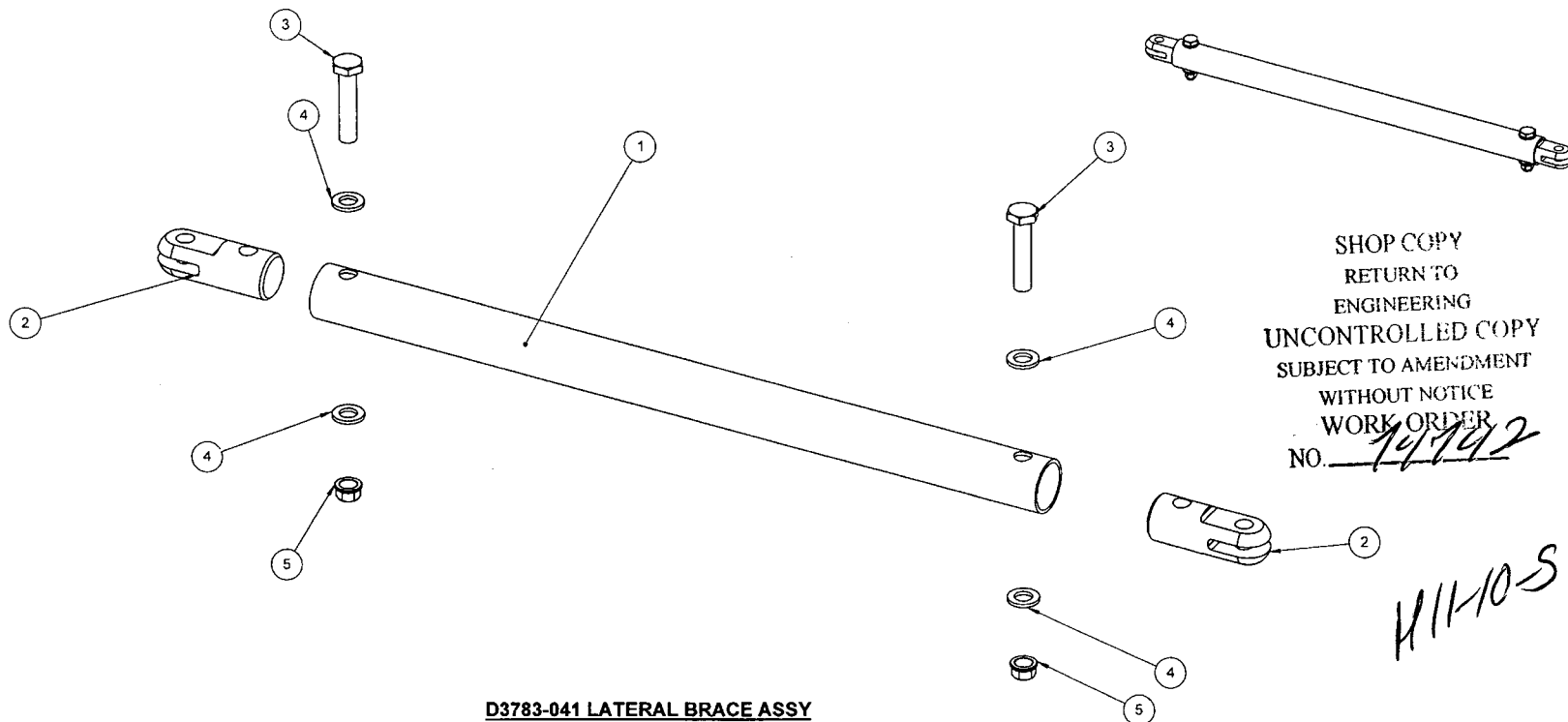
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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14742

H11-10-S

D3783-041 LATERAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3769-1	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN980JD516)	4
5	MS21042L5	NUT	2

RELEASED
08.06.16/10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.52 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3783	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACE ASSEMBLY	NTS
DATE	08.06.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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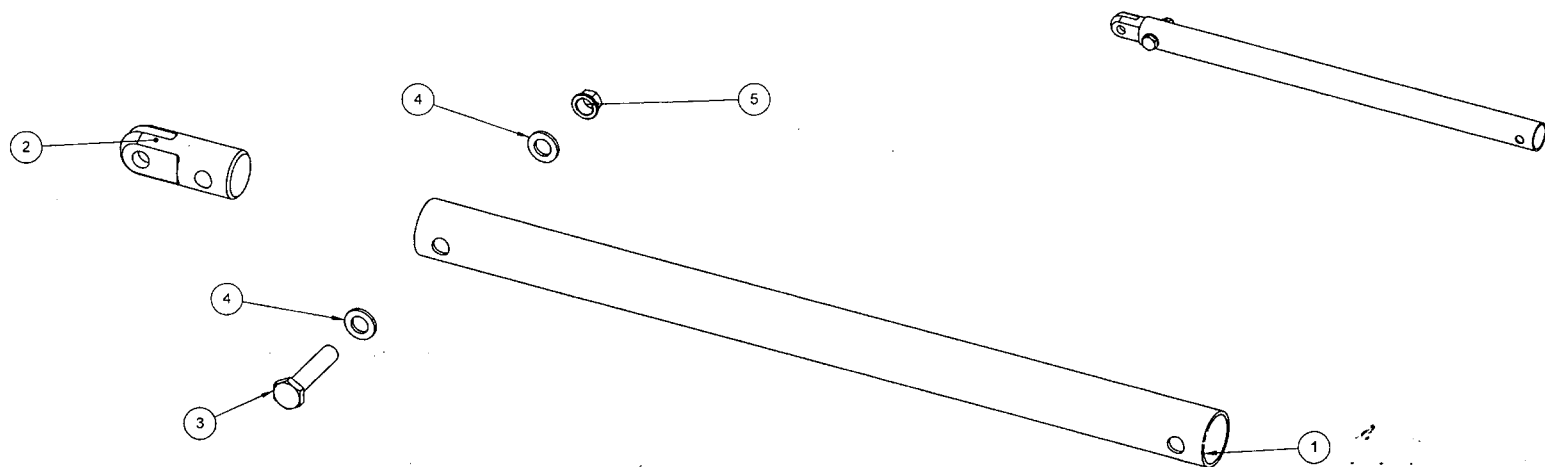
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3783-043 LONGITUDINAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3769-3	TUBE	1
2	D3765-1	CLEVIS	1
3	AN5-13A	BOLT	1
4	NAS1149D0568J	WASHER (AN960JD516)	2
5	MS21042L5	NUT	1

RELEASED
08-06-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3783	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE BRACE ASSEMBLY	SCALE NTS
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DATE	08.06.04		

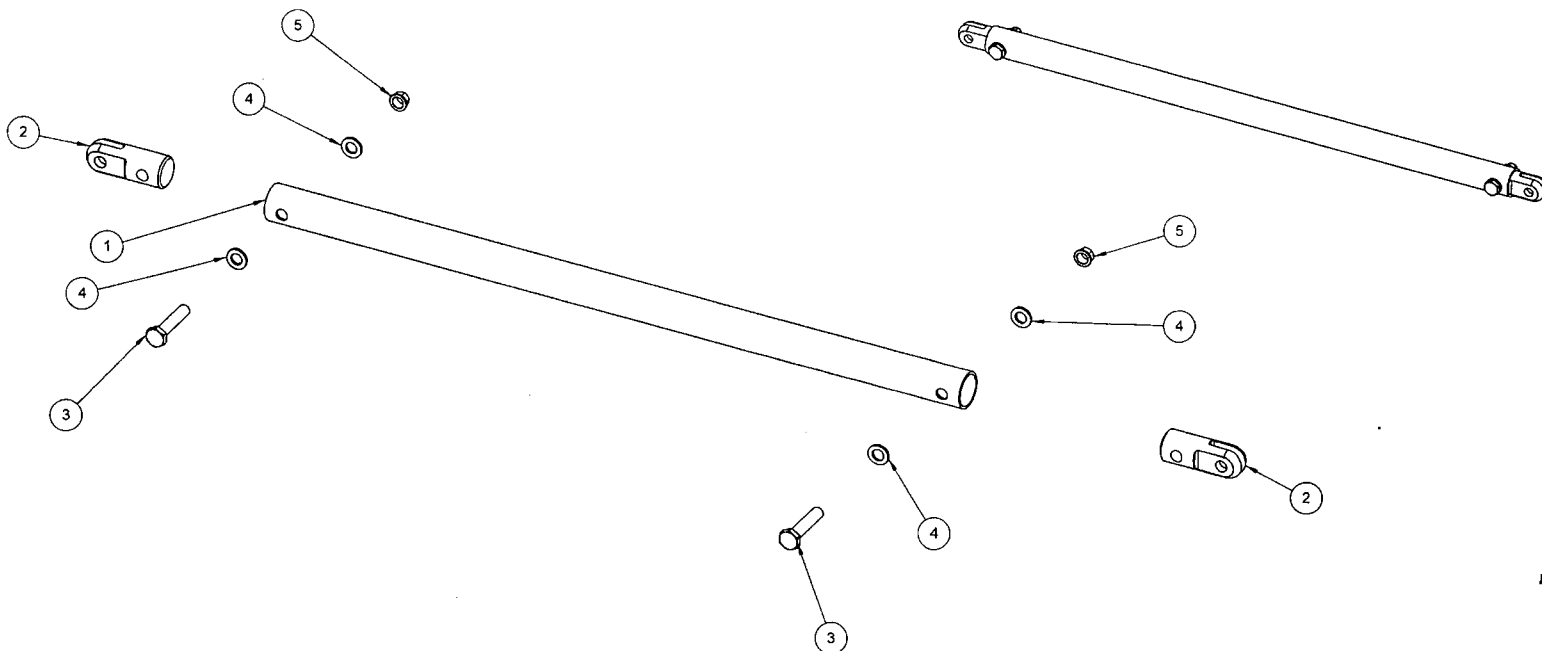
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3783-045 ANGLE BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3769-5	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

RELEASED
08-06-14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.63 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. D3783	REV. A
MFG. APPR.			SHEET 3 OF 3
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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